



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7714
Job Sheet 200604



Part No: 647.7714

Job Qty: 30 pcs

Part Name: Strut Tube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/13/19

Job Tracking No:

Due Date: 10/4/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A1 IPP REV:A 15.01.07 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Conventional Mill - 1	30 pcs	10/4/19	10/4/19	0.00	5.40	Conventional Mill - 1		
							Conventional Mill - 2		
120	QC 2	30 pcs	10/4/19	10/4/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S219908



Part: 647.7714

Job No: 200604

Serial No/Batch: S219908

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/04/19

Plex 9/13/19 1:17 PM Dart.lajeunesse.marie

125 QC 8	30 pcs	10/4/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	OK 19/10/04
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
130 Packaging 3-1 - Stock - B4B 30 pcs		10/4/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	a
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	

Plex 9/13/19 1:17 PM Dart.lajeunesse.marie

				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	30 pcs	10/4/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89

OCT 07 2019

Part Op 110 - (Manufacture as per dwg) 1- CUT AS PER DWG
Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
125 - (QC8- Inspect parts - second check)
130 - (Identify as per dwg & Stock Location: W/hold) ***Stock in large fab*** WA001
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4130NT0.500W.083	4130 Round Tube .500 X .083W	16.2000 ft (.54 ea)	110-Conventional Mill - 1	5130961

21x

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Conventional Mill - 1	M4130NT0.500W.083	16	34	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut Tube	6.500inches ± 0.005	6.505 6.495		
2	Strut Tube	0.188inches ± 0.005	0.193 0.183	Radius	
3	Strut Tube	0.500inches ± 0.005	0.505 0.495	Diameter	
4	Strut Tube	0.334inches ± 0.005	0.339 0.329	Diameter	

Plex 9/13/19 1:17 PM Dart.lajeunesse.marie

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
Completed By		Lead hand / Supervisor			
QC / QA Coordinator					

303 .750



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2745
Job Sheet 200629



Part No: D2745

Job Qty: 100 pcs

Part Name: Bushing

160 pcs.

B.A

Job 200629?



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/13/19

Job Tracking No:

Due Date: 10/14/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP C 02.03.07 Update to turn in house NG IPP Rev:D 07-10-23 Removed tumbling JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Hardinge - 1	100 pcs	10/14/19	10/14/19	0.01	7.33	Hardinge - 1	BM 10-10-04
120	QC 8	100 pcs	10/14/19	10/14/19	0.00	0.00	QC 8 - 12	
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	
							QC 8 - 52	
							QC 8 - 23	
							QC 8 - 57	
							QC 8 - 76	
130	Packaging 3-1 - Stock - B4B	100 pcs	10/14/19	10/14/19	0.00	0.00	Packaging 3 - 1 - B4B	
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B ✓	TP 001

Plex 9/13/19 10:57 AM Dart.lajeunesse.marie



Container No: S219776



Part: D2745

Job No: 200629

Serial No/Batch: S219776

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/04/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

	Packaging 3 - 4 - B4B					
	Packaging 3 - 5 - B4B					
	Packaging 3 - 6 - B4B					
	Packaging 3 - 7 - B4B					
	Packaging 3 - 8 - B4B					
	Packaging 3 - 9 - B4B					
	Packaging 3 - 10 - B4B					
	Packaging 3 - 11 - B4B					
	Packaging 3 - 12 - B4B					
	Packaging 3 - 13 - B4B					
	Packaging 3 - 14 - B4B					
	Packaging 3 - 15 - B4B					
	Packaging 3 - 16 - B4B					
	Packaging 3 - 17 - B4B					
	Packaging 3 - 18 - B4B					
	Packaging 3 - 19 - B4B					
	Packaging 3 - 20 - B4B					
	Packaging 3 - 21 - B4B					
	Packaging 3 - 22 - B4B					
	Packaging 3 - 23 - B4B					
	Packaging 3 - 24 - B4B					
	Packaging 3 - 25 - B4B					
	Packaging 3 - 26 - B4B					
	Packaging 3 - 27 - B4B					
	Packaging 3 - 28 - B4B					
	Packaging 3 - 29 - B4B					
	Packaging 3 - 30 - B4B					
	Packaging 3 - 31 - B4B					
	Packaging 3 - 32 - B4B					
	Packaging 3 - 33 - B4B					
	Packaging 3 - 34 - B4B					
	Packaging 3 - 35 - B4B					
	Packaging 3 - 36 - B4B					
	140 QC 21 - SA	100 pcs	10/14/19	0.00 0.00	QC 21 - SA - 21 ✓	FP001
	160 pcs OCT 0 8 2019				QC 21 - SA - 70	
					QC 21 - SA - 53	
Part Op 100 - 1-Turn as per Dwg D2515						
Descriptions: 120 - (QC8- Inspect parts - second check)						
130 - (Identify as per dwg & Stock Location:) LOCATION : FP001						
140 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
M303R0.750	303 Round Bar 0.750	9.5900 ft (.0959 ea)	100-Hardinge - 1	S203380		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Hardinge - 1	M303R0.750	10	127	0		

217"

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.060inches ± 0.010	0.070 0.050	0.059	
2	Bushing	0.400inches ± 0.010	0.410 0.390	0.399	
3	Bushing	0.060inches ± 0.010	0.070 0.050	0.059	
4	Bushing	1.020inches ± 0.010	1.030 1.010	1.021	
5	Bushing	0.030inches ± 0.010	0.040 0.020	0.035	
6	Bushing	20.000Degrees ± 0.000	20.000 20.000	20°	
7	Bushing	0.472inches ± 0.010	0.482 0.462	0.472	
8	Bushing	0.375inches + 0.006 - 0.001	0.381 0.374	0.375	
9	Bushing	0.560inches ± 0.010	0.570 0.550	0.560	
10	Bushing	0.750inches ± 0.010	0.760 0.740	0.745	

Plex 9/13/19 10:57 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐			DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date :	Sequence #:	QTY Affected :		MRB (QS1042)			
Description Work Order Deviation		Disposition					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐				Completed By Lead hand / Supervisor QC / QA Coordinator	